



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB KIT 407M
Job Sheet 189627



Part No: RB KIT 407M

Job Qty: 1 pcs

Part Name: Spline Measuring



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/29/19

Job Tracking No:

Due Date: 4/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *07-000 3940*

Note: DWG RB KIT 407M REV.D IPP REV A 18.01.25 NEW ISSUE RQ VERIFIED BY DP/IPP Rev B 18.03.08 DWG update Rev. C DP Verify DD/IPP Rev. C 19.01.24 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	4/8/19	4/8/19	0.00	1.00	Small Fab - 1		<i>MLC</i>
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	4/8/19	4/8/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	1 pcs	4/8/19	4/8/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		



Container No: S161889



Part: RB KIT 407M

Job No: 189627

Serial No/Batch: S161889

Revision: D

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/13/19

MAR 14 2019
DAS 40
9:39

Plex 1/29/19 9:15 AM Dart.lajeunesse.marie

				Packaging 3 - 6 - B4B	DAS					
				Packaging 3 - 7 - B4B	28					
				Packaging 3 - 8 - B4B	9-89					
				Packaging 3 - 9 - B4B						
				Packaging 3 - 10 - B4B						
				Packaging 3 - 11 - B4B						
				Packaging 3 - 12 - B4B						
				Packaging 3 - 13 - B4B						
				Packaging 3 - 14 - B4B						
				Packaging 3 - 15 - B4B						
				Packaging 3 - 16 - B4B						
				Packaging 3 - 17 - B4B						
				Packaging 3 - 18 - B4B						
				Packaging 3 - 19 - B4B						
				Packaging 3 - 20 - B4B						
				Packaging 3 - 21 - B4B						
				Packaging 3 - 22 - B4B						
				Packaging 3 - 23 - B4B						
				Packaging 3 - 24 - B4B						
				Packaging 3 - 25 - B4B						
				Packaging 3 - 26 - B4B						
				Packaging 3 - 27 - B4B						
				Packaging 3 - 28 - B4B						
				Packaging 3 - 29 - B4B						
				Packaging 3 - 30 - B4B						
				Packaging 3 - 31 - B4B						
				Packaging 3 - 32 - B4B						
				Packaging 3 - 33 - B4B						
				Packaging 3 - 34 - B4B						
				Packaging 3 - 35 - B4B						
				Packaging 3 - 36 - B4B	DAS					
				140	QC 21 - FG	1 pcs	4/8/19	0.00 0.00	QC 21 - FG - 21	21
									QC 21 - FG - 70	9-89

MAR 15 201

MAR 15 2019

Part Op **100** - Small Fab - -Print sheet 3 of 5 of the dwg. for labels and cut out. -Place pins in vials with the correct label. -
 Descriptions: Assemble kit.

110 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____ - Identify and Stock

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
071600	Vials w/Lids	16 Ea (16 ea)	100-Small Fab - 1	5077812
APP-1120-E	Case	1 Ea (1 ea)	100-Small Fab - 1	5155726
RB KIT 407M-01 Gauge Pin .0240" dia.		2 pcs (2 ea)	100-Small Fab - 1	5126910
RB KIT 407M-03 Gauge Pin .0400" dia.		2 pcs (2 ea)	100-Small Fab - 1	5124945
RB KIT 407M-05 Gauge Pin .0540" dia.		2 pcs (2 ea)	100-Small Fab - 1	51128745
RB KIT 407M-07 Gauge Pin .0600" dia.		2 pcs (2 ea)	100-Small Fab - 1	5052110 51566 47
RB KIT 407M-09 Gauge Pin .0800" dia.		2 pcs (2 ea)	100-Small Fab - 1	5126920
RB KIT 407M-11 Gauge Pin .0960" dia.		2 pcs (2 ea)	100-Small Fab - 1	5052172 51568 3
RB KIT 407M-13 Gauge Pin .1080" dia.		2 pcs (2 ea)	100-Small Fab - 1	504787P
RB KIT 407M-15 Gauge Pin .1200" dia.		2 pcs (2 ea)	100-Small Fab - 1	5053387 5152012
RB KIT 407M-17 Gauge Pin .1440"		2 pcs (2 ea)	100-Small Fab - 1	5131277
RB KIT 407M-19 Gauge Pin .1440"		2 pcs (2 ea)	100-Small Fab - 1	5156817
RB KIT 407M-21 Gauge Pin .1600" dia.		2 pcs (2 ea)	100-Small Fab - 1	5152023
RB KIT 407M-23 Gauge Pin .1600" dia.		2 Ea (2 ea)	100-Small Fab - 1	5052184
RB KIT 407M-25 Gauge Pin .1728" dia.		2 pcs (2 ea)	100-Small Fab - 1	5047874
RB KIT 407M-27 Gauge Pin .1728" dia.		2 pcs (2 ea)	100-Small Fab - 1	5047880
RB KIT 407M-29 Gauge Pin .1800" dia.		2 Ea (2 ea)	100-Small Fab - 1	5053914
RB KIT 407M-31 Gauge Pin .1920" dia.		2 pcs (2 ea)	100-Small Fab - 1	5156833
RB KIT 407M-35 Labels	N/R	1 pcs (1 ea)	100-Small Fab - 1	N/R
RB KIT 407M-39 Bottom Foam (Ethafom 220, Black, 2.58 x 4.83 x 7.34) use with case APP-1120-E		1 Ea (1 ea)	100-Small Fab - 1	5155728
RB KIT 407M-41 Top Foam (Ethafom 220, Black, 0.45 x 4.79 x 7.26) use with case APP-1120-E		1 Ea (1 ea)	100-Small Fab - 1	5155727
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	100-Small Fab - 1	5021040

8617

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	071600	16	4,680	0
	APP-1120-E	1	6	0
	RB KIT 407M-01	2	8	0
	RB KIT 407M-03	2	8	0
	RB KIT 407M-05	2	18	0
	RB KIT 407M-07	2	1	0
	RB KIT 407M-09	2	8	0
	RB KIT 407M-11	2	1	0
	RB KIT 407M-13	2	4	0
	RB KIT 407M-15	2	3	0
	RB KIT 407M-17	2	20	0
	RB KIT 407M-19	2	1	0
	RB KIT 407M-21	2	2	0
	RB KIT 407M-23	2	41	0
	RB KIT 407M-25	2	4	0
	RB KIT 407M-27	2	6	0
	RB KIT 407M-29	2	6	0
	RB KIT 407M-31	2	1	0
	RB KIT 407M-35	1	0	0
	RB KIT 407M-39	1	1	0
	RB KIT 407M-41	1	1	0
	RB41011	1	474	0

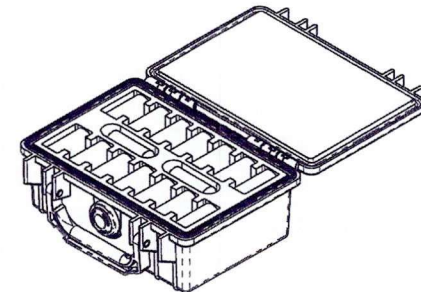
Part Specifications

Specifications could not be found.

Plex 1/29/19 9:15 AM Dart.lajeunesse.marie

ITEM #	QTY	PART #	PART TITLE
-01	2	RB KIT 407M-01	Ø.0240, CLASS X PLUG NO-GO GAUGE
-03	2	RB KIT 407M-03	Ø.0400, CLASS X PLUG NO-GO GAUGE
-05	2	RB KIT 407M-05	Ø.0540, CLASS X PLUG NO-GO GAUGE
-07	2	RB KIT 407M-07	Ø.0600, CLASS X PLUG NO-GO GAUGE
-09	2	RB KIT 407M-09	Ø.0800, CLASS X PLUG NO-GO GAUGE
-11	2	RB KIT 407M-11	Ø.0960, CLASS X PLUG NO-GO GAUGE
-13	2	RB KIT 407M-13	Ø.1080, CLASS X PLUG NO-GO GAUGE
-15	2	RB KIT 407M-15	Ø.1200, CLASS X PLUG NO-GO GAUGE
-17	2	RB KIT 407M-17	Ø.1440, CLASS X PLUG NO-GO GAUGE
-19	2	RB KIT 407M-19	Ø.1440, CLASS X PLUG NO-GO GAUGE
-21	2	RB KIT 407M-21	Ø.1600, CLASS X PLUG NO-GO GAUGE
-23	2	RB KIT 407M-23	Ø.1600, CLASS X PLUG NO-GO GAUGE
-25	2	RB KIT 407M-25	Ø.1728, CLASS X PLUG NO-GO GAUGE
-27	2	RB KIT 407M-27	Ø.1728, CLASS X PLUG NO-GO GAUGE
-29	2	RB KIT 407M-29	Ø.1800, CLASS X PLUG NO-GO GAUGE
-31	2	RB KIT 407M-31	Ø.1920, CLASS X PLUG NO-GO GAUGE
-35	1	RB KIT 407M-35	LABELS
-37	1	RB KIT 407M-37	SPLINE MEASURING KIT PACKAGING ASSY
42	16	LaContainer#071600 OR EQUIV.	CLEAR STYRENE VIAL WITH LID 5/8" ID X 1-5/8" LG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 189627 MJS
19-01-29



RB KIT 407M SPLINE MEASURING KIT



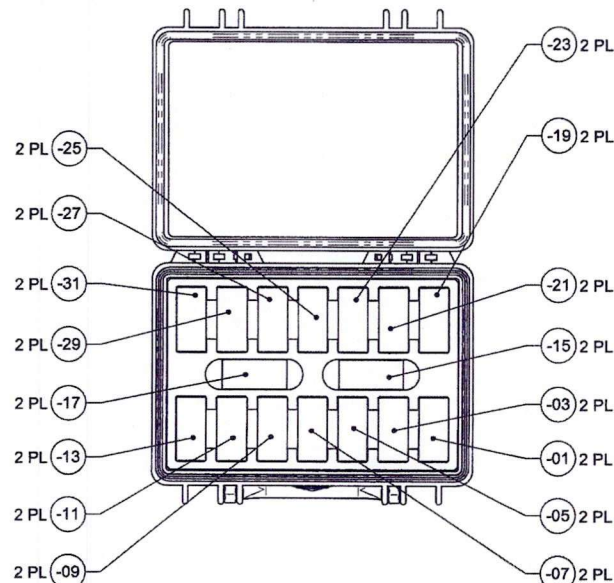
NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: N/A

7) PLACE GAUGE PINS INTO SMALL SEALABLE PLASTIC BAG WITH SMALL AMOUNT OF LPS #2 OIL TO PREVENT CORROSION THEN PLACE INTO ITEM 42

8) CUT ITEM -35 AND INSERT INTO CORRESPONDING VIAL WITH GAUGE PINS AS SHOWN



UPDATED DRAWING TEMPLATE			
D	ITEM -37 WAS HARD CASE ON LAST REVISION IS NOW PACKAGING ASSEMBLY ITEM 42 WAS ITEM -33 NOTES UPDATED		
	-01 THRU -31 ADDED NOTES. UPDATED TABLE 1 (GAUGE PIN DIMENSIONS). DIMENSION B TOLERANCE ADDED		
	-35 ADDED NOTES 1 TO 7		
	-39 ADDED NOTES 1 TO 8. DIMENSION R.13 WAS CHAMFER .50X45°		
C	-41 ADDED NOTES 1 TO 9. DIM WAS 7.26 IS 7.38. DIM WAS 4.79 IS 5.00. DIM WAS 0.45 IS 0.50. ADDED DIMENSION R.13		
	ADDRESS ON ITEM -35 CHANGED TO HAWKESBURY ADDRESS. REMOVED SPECIFIC SUPPLIER INFO		
2	-01 THRU -31 ADDED GAUGE PIN DIMENSIONS TABLE. -39 CH'D DIM WAS 64X R.06 IS 56X R.06. CH'D DEPTH WAS 16X. 44 IS 7.78. ADDED FINGER PULLS. -41 CH'D MATERIAL WAS C200 EGG SHELL, BLACK IS ETHAFOAM 220, BLACK		
1	RELEASED FOR PRODUCTION.		
REV.	DESCRIPTION	ECN #	BY
DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. D
MFG. APPR.	DP	RB KIT 407M	SHEET 1 OF 6
APPROVED	VJ	TITLE	SCALE
		SPLINE MEASURING KIT	NTS
DATE 1/17/2019			
COPYRIGHT © 2018 BY DART AEROSPACE LTD			
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					